

Date: Thursday, 10/11/2007 2:54:49 PM
 User: Kim Johnston

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : DOUBLER |
| Job Number : 35129 | |
| Estimate Number : 11317 | |
| P.O. Number : <i>N/A</i> | Part Number : D33021 |
| This Issue : 10/11/2007 S.O. No. : <i>N/A</i> | Drawing Number : D3302 REV B2 |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : <i>N/A</i> Type : SMALL /MED FAB | Drawing Revision : B2 |
| Previous Run : 33069 | Material : <i>N/A</i> |
| Written By : <i>[Signature]</i> | Due Date : 10/31/2007 Qty: 20 Um: Each |
| Checked & Approved By : <i>[Signature]</i> 07.10.11 | |
| Comment : Est Rev. A 04.09.02 New issue KJ/JLM | |
| Est Rev:B Now on Waterjet 07-06-25 JLM | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M6061T6S063 | 6061-T6 .063 Sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.8093 sf(s)/Unit Total : 16.1868 sf(s)
 6061-T6 .063 Sheet
 Material: 6061-T6 (QQ-A-250/11) 0.063" thick
 (M6061T6S.063)
 Identify for D3302-1
 Batch: *M105225K12 IB07-10-18 m18556*

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET
 1-Cut as per Dwg D3302
 Dwg Rev: *B2*
 Prog Rev: *B2*

IB07-10-18

2-Deburr if necessary

IB07-10-18

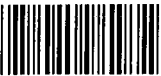
| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB07-10-18

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

*5**07/10/18**(420)**counter*

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DE Date: 09/12/24
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 10/11/2007 2:54:50 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 35129

Part Number: D33021

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr break all unmarked sharp edges 0.005 to 0.010

JS 07/12/20 (20)

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3302

SB 07/12/20 (20)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS 07/12/20 (20)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HL 07-12-21 (20)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M/L 07/12/21 (20X)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 235*

JS 07/12/21 (20)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

JS 07/12/21 (20)

Job Completion



U 07.12.24

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

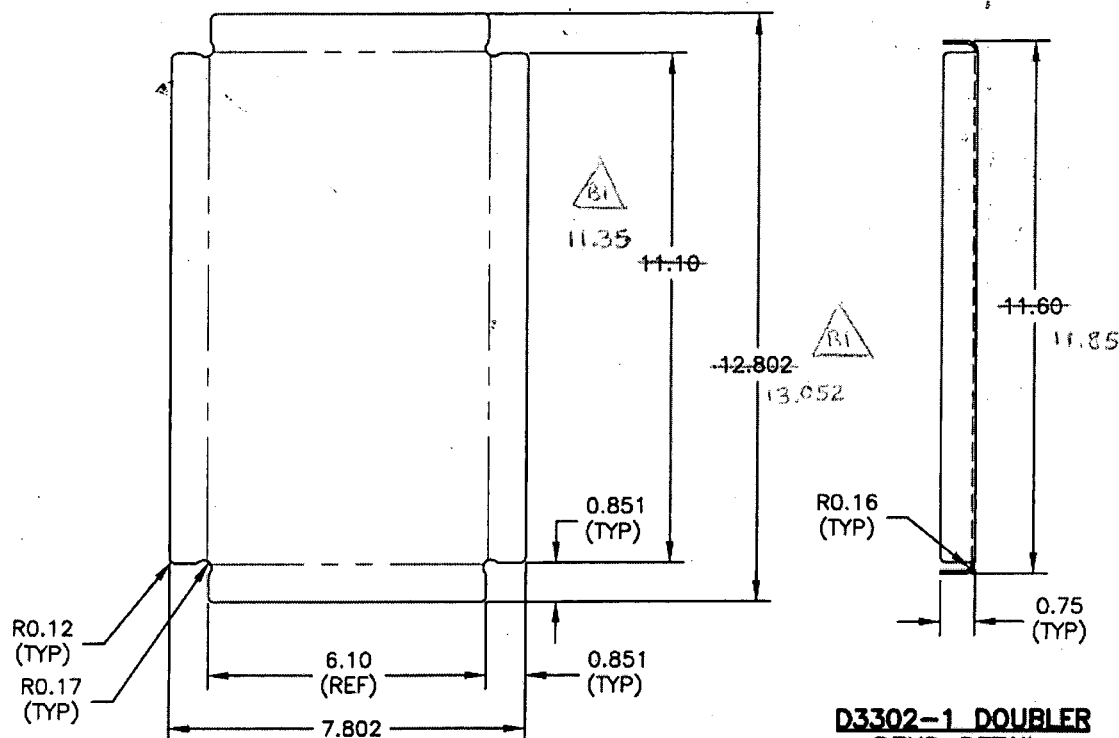
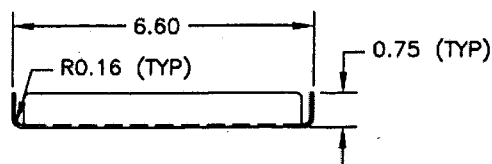
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | |
|------------------|------------------|--|------------------------|
| DESIGN T# | DRAWN BY T# | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED H# | APPROVED H# | DRAWING NO. D3302 | REV. B SHEET 1 OF 4 |
| DATE 04.11.18 | TITLE DOUBLER | SCALE 1:4 | |
| A | 04.07.06 | NEW ISSUE | |
| B | 04.11.18 | REMOVE HOLES | |
| B1 | 04.12.15 | ADDED 0.25" TO THE LENGTH FOR -1/-3 | |
| B2 | 05.03.21 | 7.25 WAS 7.34 ; 8.95 WAS 9.042 ; 7.75 WAS 7.84 FOR D3302-3 | |

RELEASED
04.11.23**D3302-1 FLAT PATTERN****D3302-1 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

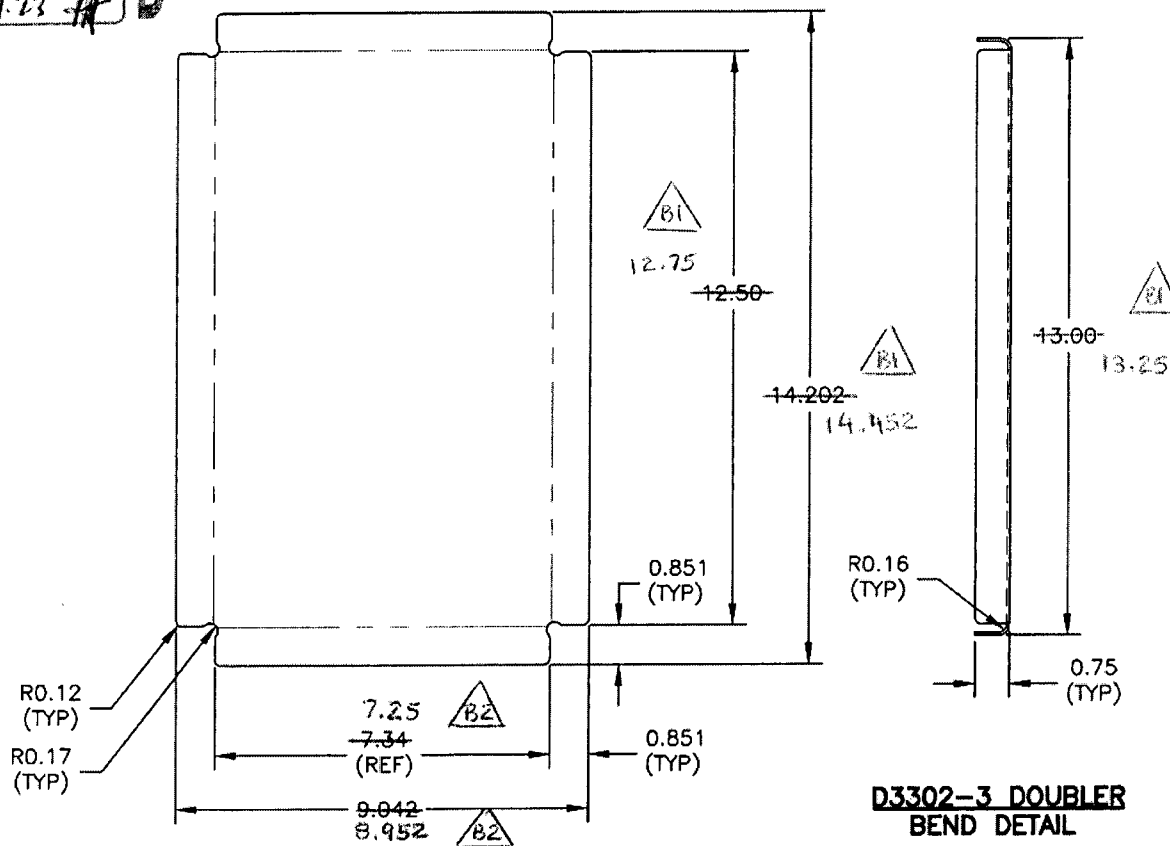
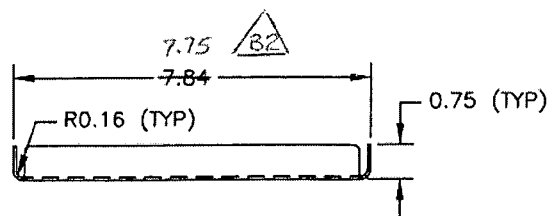
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| CHECKED # | APPROVED # | DRAWING NO. D3302 | REV. B SHEET 2 OF 4 |
| DATE 04.11.18 | | TITLE DOUBLER | SCALE 1:4 |

RELEASED
04.11.23**D3302-3 FLAT PATTERN****D3302-3 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & BATCH USING FINE POINT PERMANENT MARKER

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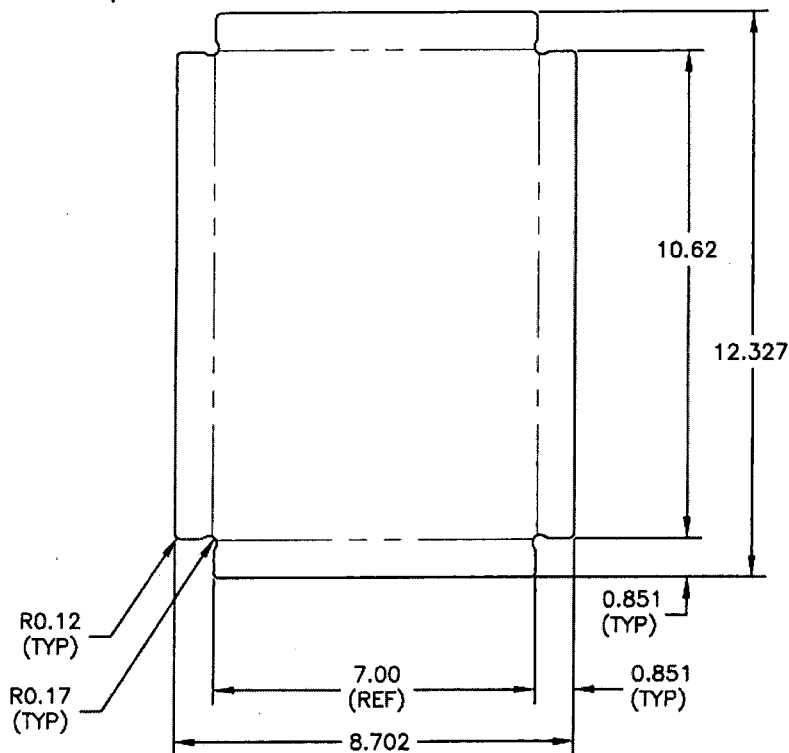
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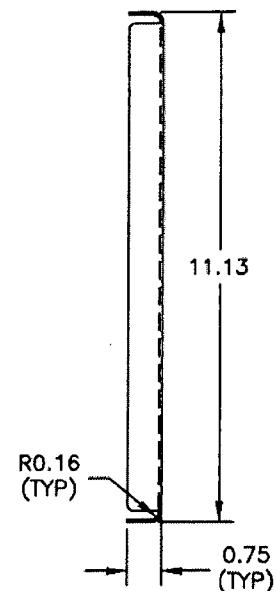


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| DATE 04.11.08 | TITLE DOUBLER | | SCALE 1:4 |

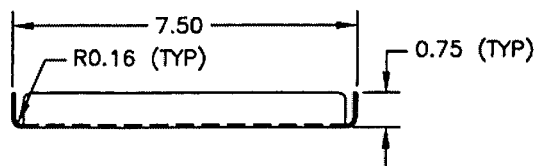
RELEASED
04.11.23 [Signature]



D3302-5 FLAT PATTERN



**D3302-5 DOUBLER
BEND DETAIL**



D3302-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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| DATE 04.11.18 | | TITLE DOUBLER | SCALE 1:1 |